

Pipeweld 8010

Cellulosic electrode with an increase in deposition rate for both stove-pipe and conventional techniques. Suitable for welding pipe steels API 5LX: X42-X65

Specifications

Classifications	SFA/AWS A5.5 : E8010-G
	EN 499 : E 46 2 Z C 21
	ISO 2560 : E 51 3 C 10

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	480 MPa	560 MPa	24 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	0 °C	75 J
As Welded	-20 °C	65 J

Deposition Data

Diameter	Current	Voltage
5 mm	110-170 A	31 V
3.2 mm	60-110 A	31 V
4 mm	90-140 A	32 V